



V&F-001

PATENT

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

08 654760

In re Application of: Vora, Madhukar B.) Art Unit: UNKNOWN
Serial No. Unknown) Examiner: UNKNOWN
Filed: May 29, 1996) Atty Docket: V&F-001

For: **VERTICALLY INTEGRATED FLASH EEPROM FOR GREATER DENSITY AND LOWER COST**

BOX PATENT APPLICATION

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Enclosed for filing please find a new Patent Application entitled **VERTICALLY INTEGRATED FLASH EEPROM FOR GREATER DENSITY AND LOWER COST** filed on behalf of Madhukar B. Vora and including 18 pages of specification (including claims and abstract), and having 2 independent claims and 2 total claims, a 1 page abstract, and having 9 sheets of drawing figures comprising Figures 1-34, an original ink signed Declaration for Patent Application, and an original ink signed Independent Inventor's Declaration and a return postcard. The attorney's Docket Number is V&F-001.

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VERTICALLY INTEGRATED FLASH EEPROM
FOR GREATER DENSITY AND LOWER COST

5 BACKGROUND OF THE INVENTION

The invention pertains generally to the field of semiconductor, nonvolatile memories, and, more particularly, to the field of vertically-integrated, flash EEROMS which can be manufactured with sufficient density to be cheap enough to compete with rotating magnetic media for bulk memory applications. The vertically-integrated, flash EEPROM according to the

10 teachings of the invention is especially useful in personal computers of the laptop, notebook and palmtop variety although it is broadly applicable to any ^{application} ~~application~~ where large, nonvolatile memory is needed which is physically rugged and competitive with disk drives in price.

Flash EEPROMS are known in the prior art, but the problem to date has been that they cannot be made cheaply enough for them to have mass market appeal. The size of prior art

15 EEPROM cells has been so large, that the number of cells per semiconductor die that can be made with adequate yield was too low to have a cost which was competitive with rotating memories such as disk drives.

Prior art flash EEPROM cells of the most aggressive design made by Intel Corporation of Santa Clara, California are 7-8 square microns using 0.8 micron design rules. With a
20 semiconductor die size of 1 square centimeter, this cell size allows flash EEPROMS of 4-8 megabits to be built for a cost of about \$30 per megabit.

In contrast, small disk drives can be manufactured for about \$5 per megabyte. Therefore, a need has arisen for a smaller flash EEPROM cell such that more dense memories can be built for lower cost.

25 SUMMARY OF THE INVENTION

According to the teachings of the invention, a vertically constructed flash EEPROM cell is taught herein which allows a cell size of 2-4 square microns to be achieved. With present 6 inch wafers and 0.8 micron design rules and 40,000-60,000 square mil dies, the cost per megabit of memory cells is a substantial improvement over the \$30 per megabit cost of prior
30 art EEPROM cells. With the migration toward 8 inch wafers and 0.6 micron design rules larger die sizes of 100,000-200,000 square mils will be possible, and the cost per megabit of memory cells according to the teachings of the invention should improve greatly.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a cross-sectional view of a semiconductor substrate at an intermediate stage in construction of a vertical EEPROM cell after the recessed gate window has been formed and first polysilicon has been deposited.

5 Figure 2 is a cross-sectional view of a semiconductor substrate at an intermediate stage in construction of a vertical EEPROM cell after the floating gate has been formed.

Figure 3 is an equivalent circuit showing the two capacitors of the floating gate structure.

Figure 4 is a vertical cross-sectional diagram of a typical prior art EEPROM cell 10 through the floating gate structure.

Figure 5 is a vertical cross-sectional diagram of the finished vertical EEPROM structure.

Figure 6 is a plan view of a cell array using the vertically oriented EEPROM cells according to the invention.

15 Figures 7A, B and C through Figures 31A, B and C are cross-sectional views showing various stages of simultaneous construction of an NMOS transistor, a PMOS transistor and a vertically oriented EEPROM cell according to a process compatible with fabrication of CMOS drivers for the EEPROM array according to the teachings of the invention.

Figure 32 is a plan view of four cells in an array of EEPROM cells according to the 20 teachings of the invention.

Figure 33 is a sectional view through a typical EEPROM cell according to the teachings of the invention taken along section line A-A' in Figure 32.

Figure 34 is a sectional view through a typical EEPROM cell according to the teachings of the invention taken along section line B-B' in Figure 32.

25 DETAILED DESCRIPTION OF THE INVENTION

Referring to Figure 1, there is shown a cross-sectional view of an intermediate stage in the construction of the EEPROM memory cell according to the teachings of the invention.

Although a detailed process schedule and series of drawings illustrating the exact method of making one embodiment of the invention will be presented below, Figures 1-3 will be used to 30 summarize the construction of an EEPROM memory cell according to the teachings of the invention.

To reach the stage of construction shown in Figure 1, a one micron deep well is etched into an N type silicon substrate 10 having a resistivity of _____. A P doped region 12

is formed about midway down the well. An N doped region 14 lies above the P type region 12. An oxide layer 16 having a thickness of about 2000 angstroms is grown on top of the substrate. An oxide layer 18 is grown at the bottom of the well and has a thickness of about 1000 angstroms. A thin annular oxide layer, sections of which are shown at 20 and 20', is grown on the sidewalls of the well to insulate a first layer of doped polysilicon 22 which is deposited on the surface of the substrate and into the well.

Figure 2 shows a subsequent stage of construction after an anisotropic etchback to remove the upper portions of the first polysilicon layer and the first polysilicon lying in the bottom of the well above oxide layer 18. This leaves a floating gate comprised of an annular first polysilicon layer, two sections of which are shown at 22 and 22'. This floating gate is isolated from the substrate by the thin oxide layer 20. To complete the electrical isolation of the floating gate layer 22, a layer of ONO insulator 24 is deposited over the surface of the substrate and in the well.

The thickness and integrity of the ONO layer is important to the coupling ratio in an EEPROM which is important in the write process. Referring to Figure 3, there is shown an equivalent circuit of the floating gate and control gate structure shown in Figure 4. Although Figure 4 represents the structure of a typical prior art floating gate EEPROM structure, it is used here to illustrate the functioning of an EEPROM cell and the significance to the write process of the coupling ratio between the capacitance of capacitor C2 and the capacitor C1 in Figure 3. Capacitor C2 represents the capacitor formed between the control gate 31 and the floating gate 33 in Figure 4. Capacitor C1 represents the capacitor formed between the floating gate 33 and the substrate 39. Layers 35 and 37 are thin oxide or ONO insulating layers (oxide-nitride-oxide) that separate the polysilicon one floating gate layer 33 from the substrate 39, and the polysilicon one floating gate layer from the polysilicon two control gate layer 31, respectively. These two insulation layers separating the conductive polysilicon layers define the capacitors C1 and C2 in Figure 3. Two oxide spacer layers 51 and 53 insulate the self aligned edges of the stacked control gate and floating gate structure.

One problem with the prior art stacked structure of Figure 4 was leakage at the corner 57 where ONO is used for insulation layer 37. At this corner, ONO joins the oxide of the spacer layer 51 (the same holds true for the other side) and the electrical seal against charge leaking out of the floating gate is not perfect because of the concentration of electric field lines at this corner.

The significance of the coupling ratio pertains to the effectiveness of causing injection of

electrons or wells into the floating gate 33 so as to alter the trapped charge therein. It is the presence of trapped charge in the floating gate 33 which alters the threshold of the MOS transistor formed by the floating gate 33, and the source region 41 and the drain region 43 in Figure 4. For one state of trapped charge, an inversion of conductivity type in the substrate 39
5 between the source and drain regions will occur thereby forming a conductive channel through which conduction occurs between the source and drain regions. This channel is symbolized by dashed line 45, and this state of charge can be defined as either a binary 1 or 0. In the other state of charge of the floating gate, no inversion channel occurs, and no conduction between the source and drain occurs. Charge is trapped in the floating gate 33 by tunneling or injection
10 during the write or program process. It is desirable to have the capacitance of capacitor C1 much less than the capacitance of capacitor C2 to insure that sufficient injection or tunnelling of electrons from the source or channel region into the floating gate occurs during the write process. This injection or tunnelling phenomenon occurs when approximately 15 volts is applied to the control gate terminal 47 in Figure 3 and approximately 8 volts is applied to the
15 source 49 during the write process if C2 is greater than C1. C2 and C1 effectively form a voltage divider between the potential applied to the control gate terminal 47 and the potential of the channel region. It is desirable to have relatively more of the voltage drop from the channel to the control gate terminal 47 occur across capacitor C1 to maximize the tunnelling phenomenon. In other words, when the programming voltage is applied, tunnelling current
20 begins to charge up both capacitors. The smaller capacitor C1 charges up to a higher voltage thereby altering the threshold of the MOS transistor sufficiently to create the inversion channel.

Therefore, since the first oxide layer 35 in Figure 4 or 20 in Figure 2 should be very thin to increase the capacitance of C1 to enhance tunnelling current for writing and erasing, it
25 is necessary for the second oxide layer 37 to be as thin or thinner than the first oxide layer so that C2 is greater than C1. Alternatively, the area of C2 can be made greater than the area of C1. Because of the need for a thin second insulator layer, the material used for the second insulating layer 37 is very important in that it must have high electrical integrity. Generally, ONO is preferred for this purpose because of its high integrity as an electrical insulator and
30 oxide interfaces on both surfaces. Because ONO creates more surface states which would adversely affect the operation of the underlying MOS transistor, ONO cannot be used for the first insulation layer 20 in Figure 2.

ONO layer 24 in Figure 2 is made by oxidizing the underlying layers to a thickness of

about 30 angstroms and then depositing approximately 150 angstroms of nitride. Thereafter, steam oxidation of the nitride is performed to form an additional 30 angstroms of oxide. Because of the different dielectric constant of nitride, the overall dielectric constant of the ONO layer 24 is approximately the same as that of 100 angstroms of oxide. ONO works especially well to

- 5 preserve the trapped charge in the floating gate to alleviate a problem of escaping charge at the corners of the floating gate which existed in the prior art.

After the ONO layer 24 is deposited, a second layer of doped polysilicon 28 is deposited to fill the well and is etched to form the word line.

- Figure 5 shows in vertical section the completed device. To reach the state of
10 construction shown in Figure 5, a layer of oxide 29 is grown on the second polysilicon layer 28.

Then a mask is formed over the second polysilicon layer 28 to protect the portion thereof overlying the well which it fills. Thereafter, an anisotropic etch is performed to etch down through the polysilicon layer 28, the ONO layer 24, the oxide layer 16 and part of the way through the N-type silicon layer 14 to open a contact well for the bit line 30.

- 15 After this contact well is opened, an annular oxide spacer, sections of which are shown at 32 and 32', is formed to seal and insulate the sides of the structure from the bit line to be formed next. The oxide spacer is formed by growing or depositing a layer of oxide over the entire structure and anisotropically etching it back to leave the vertical sections of oxide.

- The bit line is shared by all devices in a row and is formed by depositing a third layer of
20 polysilicon 30 over the entire structure and etching it to selectively make contact with the N-type silicon layer 14 which forms the drain of the vertical annulus MOS transistor formed inside the well. The source of the vertical MOS transistor is the N-type substrate 10. The channel region for this transistor is formed by the P-type silicon layer 12. The gate oxide between the channel region and the floating gate 22 is oxide layer 20. The control gate is
25 comprised of second polysilicon layer 28, and extends down into the page and up out of the page to form the word line.

- Figure 6 shows a plan view of the EEPROM cell. Field oxide 40 defines the outer boundaries of the N-type silicon layer 14 through which the wells 14 and 42 are formed. The polysilicon or metal bit line 30 (polysilicon is shown and preferred for better step coverage)
30 runs from left to right over and in contact with the N-type silicon layer 14 and slightly overlaps the field oxide layer. The bit line also overlaps the word line polysilicon 28 which fills the well 11. The details of the structure down inside the well are not shown in Figure 6 for simplicity.

The length of the cell shown in Figure 6 is equal to the dimension A defining the length of the well plus the dimension B which defines the pitch or minimum spacing between the wells. In Figure 6, the next row of wells is represented by wells 48 and 50. For 0.6 micron design rules, $A = 0.6$ micron and $B = 0.6$ microns for a total length of 1.2 microns.

5 The width of the cell is equal to the dimension C which defines the width of the well, plus the dimension D which defines the overlap of the second polysilicon layer 28 past the edge of the well, plus the dimension E equal to the pitch between the second polysilicon word lines 28 between columns. For 0.6 micron design rules, $C = 0.6$ microns, $D = 0.05$ microns and $E = 0.6$ microns for a total cell width of 1.3 microns. Thus, the total cell area for 0.6 micron design
10 rules is 1.56 square microns.

With a cell size of 1.56 square microns, a 64 megabit EEPROM memory can be built on a die of 1-2 square centimeter size. With 6 inch wafers, the wafer area is 28 square inches. At 6.54 square centimeters per square inch, a 6 inch wafer contains 182 square centimeters. With a die size of 2 square centimeters, a 6 inch wafer yields about 90 die. Because well known
15 redundancy techniques can be used to repair defective cells, yields in EEPROM production are typically high, averaging around 80 percent. Thus, a typical production run will yield about 72 good die. Typical production costs for a 6 inch wafer are about \$500, so the cost per 64 megabit (8 megabytes) die is about \$6.94 or about \$0.86 per megabyte. A 40 megabyte EEPROM memory using the teachings of the invention would cost about \$34.72. This cost should
20 come down with the introduction of 8 inch wafers at 0.6 micron line widths. Typical costs are expected to be about \$3.87 per 8 megabyte EEPROM memory or 48 cents per megabyte for a total cost for a 40 megabyte memory of \$19.37. Of course any change in any of the numbers of assumptions or numbers used in the above calculations will yield different costs per megabyte. Today's cost for typical prior art EEPROM memory sold by Intel Corporation is about \$30 per
25 megabyte manufactured using 0.8 micron design rules. Note that in the above cost calculations, 0.6 micron linewidths were assumed. Costs for prior art EEPROM cells using 0.6 micron design rules should fall to about \$15 per megabyte.

A detailed description of how to make the EEPROM memory cell according to the teachings of the invention follows in connection with the discussion of Figures 7A, B and C through Figures
30 30A, B and C. The preferred process is compatible with CMOS processing so that the EEPROM memory can be built on the same die with CMOS drivers. Accordingly, in each of Figures 7A, B and C through Figures 30A, B and C, the figures in the left column labelled Figure _A is the corresponding NMOS structure and the figures in the right column labelled Figure _C is the

corresponding PMOS structure. A summary of the process is given in Appendix A. In Appendix A, the individual steps in the process are numbered, and the steps in which the masks are used are given in the column second from the right. The figure numbers in the rightmost column of Appendix A show the state of construction after the steps preceding the line on which the

5 particular figure number is listed have been completed.

Referring to Figures 7A, B and C, there is shown the state of construction after the first 12 steps in Appendix A. To reach the state of construction shown in Figures 7A, B and C, a P-type silicon substrate having a conventional resistivity is used as the starting material.

Then a layer of oxide (silicon dioxide) is thermally grown to a thickness of
10 approximately 300 angstroms.

Next a layer of nitride (silicon nitride) is deposited to a thickness of about 1000 angstroms using chemical vapor deposition (CVD), low pressure CVD (LPCVD) or plasma enhanced chemical vapor deposition (PECVD).

A layer of photoresist is then deposited and developed using the first level twin-well
15 mask to define the twin wells needed to form CMOS devices.

After forming the twin well mask layer of photoresist, the nitride layer is etched away over an area to be implanted with phosphorous to form an N-type well in which to form the PMOS device. Any process for etching the nitride will suffice.

To form the N-well, phosphorous is implanted to a depth of about 3000 angstroms using
20 conventional dosage levels. Then the phosphorous is driven in and the N-well area has another layer of oxide grown thereover using a 1000 degree centigrade oven for one hour. This leaves the structure as shown in Figure 1 with an N-well 62 for the PMOS device, and N-well 64 in which the EEPROM device is to be constructed, and a P-well 66 in which the NMOS device is to be built.

25 Next, the photoresist and nitride are stripped, and boron is implanted to form the P-well. Both wells are then driven deeper using a 1100 degree centigrade oven for 5 hours to form wells that are 5-6 microns deep.

The oxide is then etched away over the N-well to clear the substrate surface for further processing.

30 Finally, a 1000 angstrom nitride layer is grown as shown in Figures 8A, B and C with the oxide and nitride layers shown as a single layer at 68.

Next, a layer of photoresist is deposited and an active mask (mask 2) is used to cross-link (develop) sections thereof to leave the structure as shown at Figures 8A, B and C with a

photoresist section 70 over the P-well, photoresist section 72 over the EEPROM cell area and photoresist section 74 over the N-well.

The oxide/nitride layer 68 is then etched using the photoresist as a mask to leave the structure as shown in Figures 9A, B and C.

- 5 A field implant must be performed to implant boron at the edges of the active area of the NMOS device to prevent the formation of parasitic channels, i.e., unintended MOS transistors. To perform this implant, it is necessary to mask off the N well of the PMOS device. This is done by depositing a layer of photoresist 76 and developing it with the field implant mask, i.e., mask 3 to leave the second photoresist layer 76 covering the N well. A boron implant is then
- 10 performed to deposit the P-type field implant impurities shown at 78 in Figure 10A.

After the field implant, the field regions outside the active areas are oxidized to a thickness of 6000 angstroms to leave the structure as shown in Figures 11A, B and C. The field oxide is shown at 80. The areas under the field oxide remain doped so they do not invert and form parasitic MOS devices.

- 15 Next the fourth mask is used to remove the nitride portion of layer 68 of oxide/nitride by protecting all structures with photoresist except the oxide/nitride layers 68 over the EEPROM cells. After developing the photoresist with the fourth mask, a conventional oxide/nitride etch is performed to leave the structure as shown in Figures 12A, B and C with photoresist layer 69 protecting the NMOS and PMOS active areas. This leaves a thin layer of pad
- 20 oxide (not shown) over the EEPROM active areas.

- Leaving the photoresist 69 over the NMOS and PMOS wells to protect them, a boron ion implantation is performed through the pad oxide (not shown) to form the buried P region 82 below the surface of the N well in which the EEPROM cell is to be formed. Typically, the dosage for this implant will be $1E+12$ (on the order of 10 to the 12th power) with an energy level of
- 25 100 KEV. This implant forms the channel region in the vertical annular EEPROM cell. As the term annular is used herein, the horizontal cross section through the EEPROM transistor below the surface of the substrate can be either circular, square, rectangular or some other shape.

- Next, leaving the photoresist in place over the NMOS and PMOS devices, an arsenic implant is performed at a lower energy level to redope the area below the surface of the
- 30 substrate but above the P region 82 back to N type as shown in Figures 13A, B and C. Typically, 30 KEV is used with a dose of $1E+14$.

Still leaving the photoresist in place over the NMOS and PMOS devices, a layer of oxide 84 is grown over the EEPROM cell to leave the structure as shown in Figures 14A, B and C.

The EEPROM cell area will be used to form two vertical EEPROM devices. To start this process, a layer of photoresist is deposited and a fifth mask is used to develop the photoresist so as to open two cell etch windows over the EEPROM cell area. An anisotropic plasma etch process is then used to etch through the oxide layer 86 and etch down into the silicon to form two wells 5 88 and 90 also called recessed gate windows. These recessed gate windows must have sufficient depth to penetrate the N layer 86 and the P layer 82 and extend into the N well 64 of the EEPROM cell. This leaves the structure as shown in Figures 15A, B and C.

A pad oxide layer (not shown) 300 angstroms thick is grown next. This layer covers the first nitride layer 68 over the NMOS and PMOS devices, the oxide layer 84 over the EEPROM 10 cells and covers the walls and bottoms of the recessed gate windows 88 and 90. This pad oxide layer protects the underlying structures from a second layer of nitride to be deposited next.

A second layer of nitride 92 approximately 500 angstroms thick is then deposited over the entire structure. This layer covers the walls and the bottom of the two recessed gate windows 88 and 90.

15 An anisotropic etchback is then performed to remove all portions of nitride layer 92 except those portions on vertical surfaces, i.e., all nitride of layer 92 is removed except those portions on the walls of the recessed gate windows to leave the structure as shown in Figures 17A, B and C.

The nitride of layer 92 is then removed from the walls of the recessed gate windows 88 20 and 90 using a wet etch to leave the structure as shown in Figures 19A, B and C.

The pad oxide (not shown) underneath the second nitride layer 92 is then removed in a wet etch. Because the pad oxide layer was not separately shown, the structure after its removal looks as shown in Figures 19A, B and C.

A thin gate oxide layer 100 is then grown to insulate the polysilicon floating gate to be 25 formed later from the silicon layers 86 (drain), 82 (channel) and 64 (source). Typically, this gate oxide is grown to a thickness of 90 to 100 angstroms in a process conventional to MOS devices.

Next, a layer of P type doped polysilicon 102 is deposited over the complete structure from which the floating gate 22 in Figure 5 will be formed to leave the structure as shown in 30 Figures 20A, B and C. Typically, about 1000 angstroms of polysilicon is deposited and is doped P type with chemical dope of phosphorous either during or after deposition to a resistivity of 50 ohms per square.

To form the floating gate, the doped polysilicon is etched back off all horizontal surfaces

and part way down into the recessed gate windows 88 and 90 to leave the segments of polysilicon shown at 102 in Figure 21B. These segments of doped polysilicon 102 correspond to the floating gate 22 in the finished structure shown in Figure 5.

Electrical isolation of the floating gate is accomplished by formation of another oxide-nitride-oxide layer 104 over the entire wafer to leave the structure as shown in Figures 22A, B, C. Typically, the ONO layer 104 is formed to a thickness of 150 angstroms by a conventional process.

At this point in the process, construction of the NMOS and PMOS devices is started in parallel with the completion of the EEPROM devices. The first step in this process is to deposit a layer of photoresist and develop it with mask 6 to form an ONO protect mask 106 over the EEPROM cell area as shown in Figure 23B. Then an ONO etch and a nitride etch are performed to remove the ONO layer 104 and the nitride layer 68 over the NMOS and PMOS transistor active areas to leave the structure as shown in Figures 23A, B and C. The pad oxide under the nitride layer 68 is left in place to protect the silicon from the threshold adjust implant to be performed next.

A threshold voltage adjustment is next performed by a conventional boron implant to implant charges into the surface region of the N well 62 and the P well 66 to adjust the voltages at which the PMOS and NMOS devices turn on. The design is such that one CMOS device threshold voltage is too low and the other CMOS device threshold voltage is too high before the threshold adjust implant. Then the threshold voltages are adjusted simultaneously in the proper directions by the threshold adjust implant.

After the implant, the pad oxide (not separately shown) that was under the oxide layer 68 is etched away to prepare the NMOS and PMOS devices for growth of a thin gate oxide. During this process the photoresist mask 106 is left in place to protect the EEPROM cell area.

A thin gate oxide layer 108 is then grown over the N well 62 and the P well 66 to electrically insulate a gate electrode to be formed later from the underlying silicon. During this process the photoresist mask 106 is left in place to protect the EEPROM cell area.

Next, the photoresist mask 106 is removed, and a second doped polysilicon layer 110 is then deposited to a thickness of about 3000 angstroms. The control gates for the PMOS, NMOS and EEPROM devices will be formed from this polysilicon layer 110. This second polysilicon layer also fills the recessed gate windows 88 and 90 and covers the ONO layer 104.

A thin layer of silicon dioxide 112 is then grown over the entire second polysilicon layer 110 to a depth of about 2000 angstroms.

A seventh mask is then used to develop a layer of photoresist deposited over the second polysilicon layer 110 and oxide 112 for purposes of etching the second polysilicon layer to form the control gates of the PMOS and NMOS devices and of the EEPROM cells and the word lines corresponding to word line 28 in Figures 5 and 6. After the etch of the second polysilicon by a conventional process, the structure looks as shown in Figures 25A, B and C except that an LDD phosphorous implant to form the source and drain regions of the NMOS device has not yet been performed.

To form the source and drain regions of the NMOS devices, an 8th mask is used to develop a layer of photoresist to form an LDD implant mask over the PMOS and EEPROM devices. Then phosphorous is implanted in a conventional process using the etched second polysilicon layer 110 over the NMOS device as a mask to form self aligned LDD regions (lightly doped drain regions) shown at 114 in Figure 25A. Later, more heavily doped, deep source and drain regions will be formed, but the LDD implants prevent short channel problems.

To protect the sidewalls of the control gates of the NMOS, PMOS and EEPROM devices, a spacer oxide deposition is performed to a depth of 3000 angstroms and then the spacer oxide is etched back to form the spacer oxide regions 114 on the sidewalls of the polysilicon control gates formed from second polysilicon layer 110. The spacer etch is an anisotropic etch to remove the spacer oxide from only the horizontal surfaces.

Referring to Figures 27A, B and C, to open contact holes 118 and 120 to the EEPROM cell, a layer of photoresist is deposited and developed with a ninth mask to form a cell contact etch mask layer 116 protecting the PMOS and NMOS devices. The developed photoresist of layer 116 is also located so as to bound the outer limits of the contact holes to be etched through the ONO layer 104 and the oxide layer 84. The other boundaries of these contact holes are self aligned with the outer edges of the spacer oxide 114. Oxide layers 113 are then formed on top of the second polysilicon control gates 110 using the photoresist 116 as a mask as shown in Figure 28B.

The ONO etch and oxide etch is then performed to leave the structure as shown in Figures 27A, B and C with contact holes 118 and 120 to the N type layer 86 for the bit line connections (not shown).

To form the bit lines corresponding to the bit line 30 in Figures 5 and 6, a layer of metal or polysilicon 122 is deposited over the structure. Metal is shown at 122 in Figure 28B, but doped polysilicon is preferred for better step coverage.

Photoresist is then deposited and a tenth mask is used to develop it to form a protective layer over the EEPROM devices so as to allow removal of the metal or polysilicon off the NMOS and PMOS devices and so as to define the outlines of the bit lines. The metal or polysilicon 122 is then etched into the shape of the bit lines and removed from over the PMOS and NMOS devices
5 to leave the structure as shown in Figures 28A, B and C.

Next, to complete the NMOS device, an N+ arsenic implant must be performed in the P well. To accomplish this, a layer of photoresist is deposited and developed with an eleventh mask to protect the EEPROM cell and the PMOS active area by photoresist which is not shown in the figures. An N+ arsenic implant is then performed using this photoresist exposing the P well
10 and the polysilicon 110 and the spacer oxide 114 as a mask to form the self-aligned source and drain regions 130 and 132.

To complete the PMOS device, another layer of photoresist is deposited and developed with mask 12 to expose the N well 62 and protect the EEPROM active area and the P well 66. A P+ boron implant is then performed using this photoresist as a mask and the second polysilicon
15 control gate 110 and spacer oxide 114 as a mask to form self-aligned source and drain regions 134 and 136. This leaves the structure as shown in Figures 29A, B and C.

To repair the implant damage, the structure is annealed 1000 centigrade for 30 seconds.

To passivate the structure, a BPSG deposition is performed to a thickness of 6000 angstroms.

20 To complete the NMOS and PMOS devices, contacts to the source and drains of the PMOS and NMOS devices must be made. To do this, a layer of photoresist is deposited and developed using contact mask 13. An etch is then performed to cut the contact holes 138, 140, 142 and 144 through the BPSG layer 146.

After a contact reflow to soften the edges for better step coverage, a layer of metal is
25 then deposited to 7000 angstroms and etched to form the contacts 148, 150, 152 and 154 to complete the structure as shown in Figures 31A, B and C.

Referring to Figure 32, there is shown a plan view of four cells in an array of vertically oriented EEPROM cells according to the teachings of the invention and constructed according to a process which is compatible with the simultaneous formation of CMOS devices on the same die.

30 The outlines of two recessed gate windows in which two EEPROM cells are formed are shown at 88 and 90. First polysilicon word lines are shown at 110. The metal or second polysilicon bit lines are shown at 122. The drain regions of the EEPROM cells are shown at 123 and 125.

Figure 33 is a cross-sectional view taken along section line A-A' in Figure 32 of the

lower two EEPROM cells having recessed gate windows shown at 127 and 129 in Figure 32.

Figure 34 is a cross-sectional view of the EEPROM cells in recessed gate windows 90 and 129 in Figure 32 taken along section line B-B' therein. Structural elements in Figures 33 and 34 corresponding to elements in Figures 7A, B and C through 31A, B and C and Figure 32 have the

5 same reference numerals.

There is given below a table summarizing the above described process of building the flash EEPROM according to the teachings of the invention which is compatible with simultaneous fabrication of CMOS devices on the same die.

10 **PROCESS FLOW FOR CONSTRUCTING A SELF-ALIGNED EEPROM MEMORY CELL COMPATIBLE WITH CMOS DRIVERS ON THE SAME DIE**

STEP	DETAILS	MASK	FIGURE
1. Start with silicon substrate	P-Type, Resistivity		
2. Grow a layer of oxide	Approx. 300 angstroms		
15 3. Deposit a layer of nitride	Approx. 1000 angstroms		
4. Deposit and develop a layer of photoresist using twin well mask		Mask 1	
5. Etch nitride layer over portion of substrate to become N-well 62			
20 6. Form N-well 62 with phosphorous implant	3000 anstroms deep, conventional dosage		
7. Drive phosphorous and re-oxidize N-well 62	1000 degrees C, 1 hour		
8. Strip photoresist and nitride			
9. Implant Boron to form P-well 66			
25 10. Drive the N and P wells 62, 64 and 66 deeper	1100 degrees C, 5 hours, 5-6 microns deep after drive		Figure 7A, B and C
11. Etch oxide over N-well 62 to clear the surface thereof for further processing			
12. Grow pad oxide	300 angstroms		
30 13. Deposit nitride layer	1000 angstroms		
14. Deposit photoresist and use active mask to develop photoresist to define etch masks 70, 72, 74 for active areas		Mask 2	Figure 8A, B and C
15. Etch oxide/nitride layer 68 to define active areas			Figure 9A, B and C
35 16. Deposit a layer of photoresist and develop using a field implant mask to form field implant mask 76		Mask 3	Figure 10A, B and C
17. Boron implant to deposit field implant impurities in P well.	Conventional dosage and energy		
40 18. Grow field oxide	6000 angstroms		Figure 11A, B and C
19. Deposit photoresist and develop with mask 4 to leave exposed only the ONO layer 68 over the EEPROM cells		Mask 4	
45 20. Etch away ONO layer 68 over EEPROM cell			Figure 12A, B and C

5	21. Implant boron to form P region 82 below substrate surface throughout N well in which EEPROM is to be formed to make channel region 12 of finished device as shown in Figure 5.	100 KEV, 1E+12		
	22. Implant arsenic to redope to N type region 86 below surface but above P layer 82	30 KEV, 1E+14		Figure 13A, B and C
	23. Grow layer of oxide 84 over EEPROM cell area	2000 angstroms		Figure 14A, B and C
10	24. Deposit layer of photoresist and use cell etch mask 5 to develop to open windows for etching recessed gate windows 88 and 90		Mask 5	
15	25. Anisotropically etch recessed gate windows 88 and 90 through N layer 86 and P layer 82 into N well 64			Figure 15A, B and C
	26. Grow pad oxide layer over whole substrate to protect underlying structures from second nitride layer	300 angstroms		
20	27. Deposit second nitride layer 92 which is thinner than first nitride layer 68	500 angstroms		Figure 16A, B and C
	28. Perform nitride etchback to remove nitride of layer 92 on all horizontal surfaces and leave it covering only the vertical walls of the recessed gate windows 88 and 90	anisotropic etch		Figure 17A, B and C
25	29. Grow oxide 96 on bottoms of recessed gate windows	2000 angstroms		Figure 18A, B and C
	30. Cell nitride strip	dip off nitride in wet etch		Figure 19A, B and C
	31. Pad oxide strip	dip off pad oxide in wet etch		
	32. Grow thin gate oxide layer 100	90-100 angstroms, conventional process		
30	33. Deposit doped polysilicon layer 102 from which floating gate is to be formed	1000 angstroms doped P type to 50 ohms per square		Figure 20A, B and C
	34. Etch back doped polysilicon layer 102 from horizontal surfaces to leave floating gates			Figure 21A, B and C
35	35. Form Oxide-Nitride-Oxide layer 104 above floating gates	Conventional process, 150 angstroms		Figure 22A, B and C
	36. Form ONO protect mask 106		Mask 6	
40	37. ONO etch, nitride etch to clear PMOS and NMOS active areas for transistor formation			Figure 23A, B and C
	38. Threshold voltage adjust implant	Boron		
	39. Leaving photoresist mask 106 in place, etch away pad oxide under first nitride layer 68 to expose N well and P well silicon			
45	40. Leaving photoresist mask 106 in place, grow thin gate oxide 108 over N well 62 and P well 66	150 angstroms		
	41. Remove photoresist mask 106, and deposit doped second polysilicon layer 110 over entire structure	3000 angstroms		
50	42. Oxidize second polysilicon	2000 angstroms		Figure 24A, B and C

What is claimed:

1. A nonvolatile memory cell comprising:

a semiconductor substrate;

a vertical MOS transistor formed by alternating N-type and P-type doped layers in said substrate intersecting a well etched into said substrate, said well having a floating gate of conductive material formed therein and insulated from and overlying said alternating N-type and P-type materials by a layer of gate insulating material;

a word line contact comprising a layer of conductive material formed on said substrate so as to extend down into said well and overlie said floating gate but insulated therefrom by an insulation layer; and

a bit line contact comprising a layer of conductive material formed on said substrate so as to be in electrical contact with the drain region of said vertical MOS transistor formed in said substrate.

2. A nonvolatile memory cell, comprising:

a semiconductor substrate of a first conductivity type having a surface;

a buried layer in said semiconductor substrate doped so as to have a second conductivity type suitable to act as a channel region of a vertical MOS transistor formed in said substrate;

a first region of said semiconductor substrate between said buried layer and said surface of said substrate, and a second region of said semiconductor substrate below said buried layer, both said first and second regions being doped so as to have a first conductivity type;

a first layer of insulating material covering said surface of said substrate;

a recessed gate window in the form of a well etched in said semiconductor substrate through said first layer of insulating material, said well being deep enough to penetrate said buried layer such that the side walls of said recessed gate window intersect said buried layer and said first and second regions of said semiconductor substrate;

a second insulating layer covering the bottom of said well;

a gate insulating layer formed on the sidewall of said well;

a floating gate comprising a conductive material formed on said gate insulating layer with an insulating layer formed over said conductive material so as to electrically isolate said floating gate from all surrounding structures, said floating gate having a

dimension suitable so as to overlie at least said intersection of said well with said buried layer;

5 a word line comprising conductive material deposited on said first insulating layer so as to extend into said well far enough to overlie at least a portion of said floating gate; and

a second layer of insulating material formed over said word line; and

10 a bit line formed over said surface of said semiconductor substrate but insulated from said word line by said second layer of insulating material, and deposited in a contact window formed in said first insulating layer so as to be in electrical contact with said first region, said first region acting as a drain of said vertical MOS transistor.

add
C2
Add
C2

ABSTRACT OF THE DISCLOSURE

654,760

A nonvolatile memory in the form of a flash EEPROM with high density and low cost. A vertical MOS transistor is formed in well etched into a semiconductor substrate, the substrate having a buried layer of doped material of a first conductivity type acting as the channel region.

- 5 Source and drain regions of this transistor comprise second conductivity type layers doped in the substrate above and below the buried layer. A thin gate oxide or oxide-nitride-oxide (ONO) layer is formed in the well and a floating gate of polysilicon is formed over the gate oxide. A layer of oxide or ONO is formed over the floating gate, and a second polysilicon or metal layer is used to fill the well to form the control gate and word line. A bit line is formed of a layer of
- 10 metal or polysilicon deposited over an insulating layer on top of the word line and makes contact with the drain of the vertical MOS transistor through a contact window formed adjacent the well.

15

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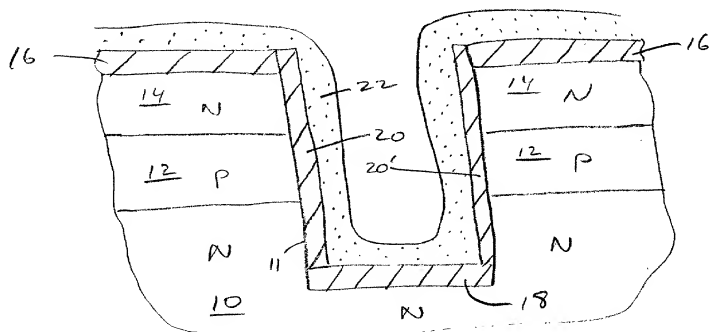


FIG. 1

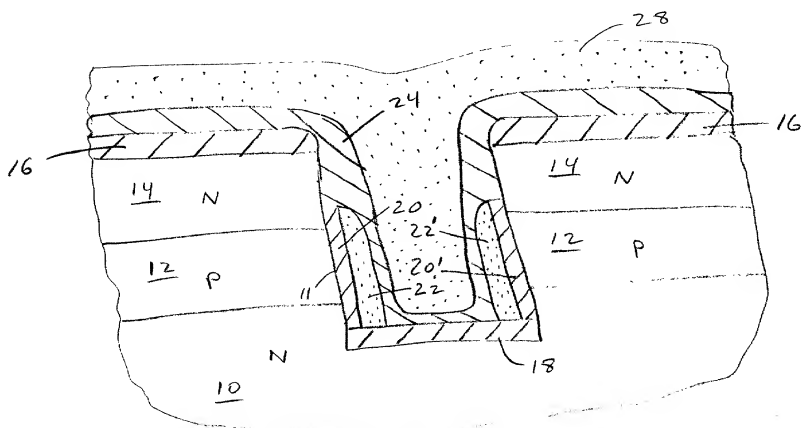


FIG. 2

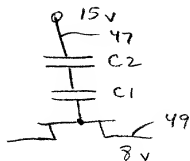


FIG. 3

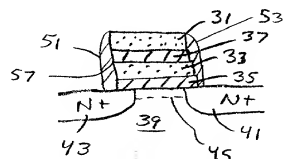


FIG. 4

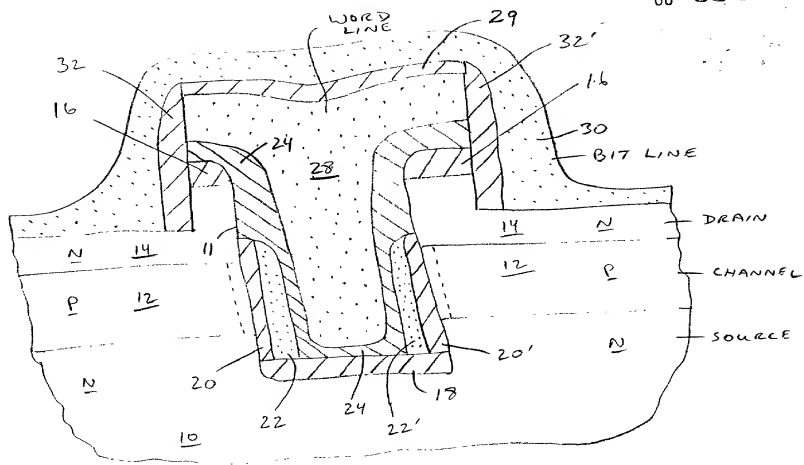


FIG. 5

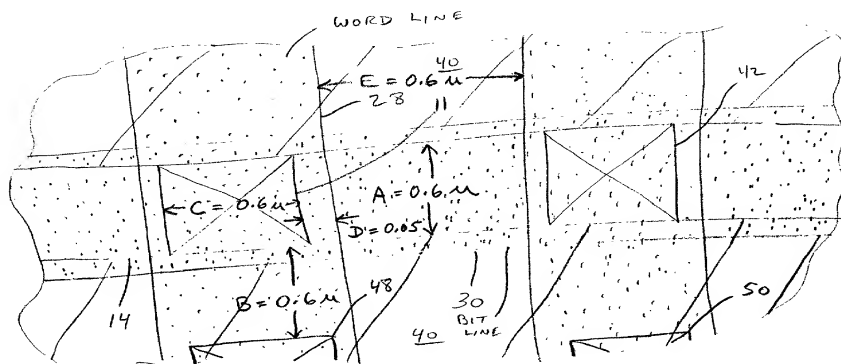


FIG. 6

Nmos

EEPROM CELL

PMOS

P
P-SILICON SUBSTRATE
66

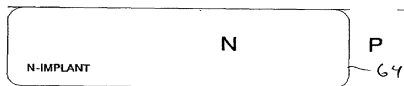


FIG. 7A

FIG. 7B

FIG. 7C

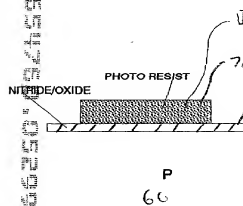


FIG. 8A

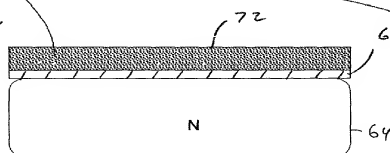


FIG. 8B

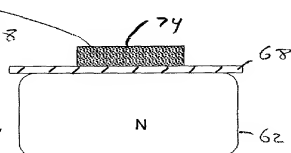


FIG. 8C

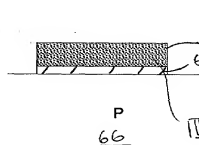


FIG. 9A

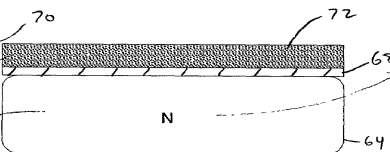


FIG. 9B

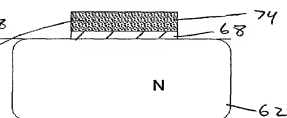


FIG. 9C

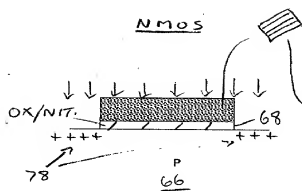


FIG. 10A

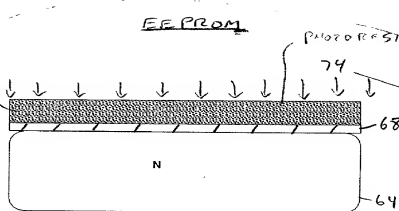


FIG. 10B

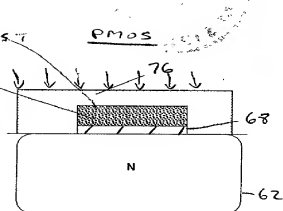


FIG. 10C

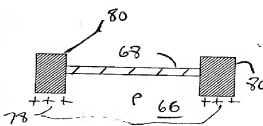


FIG. 11A

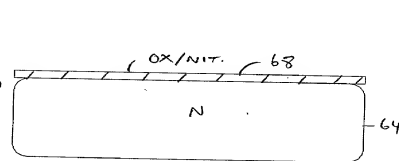


FIG. 11B

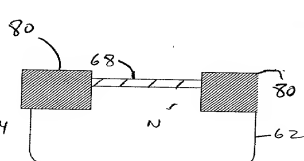


FIG. 11C

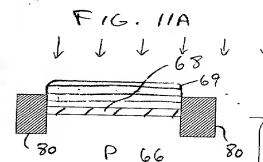


FIG. 12A

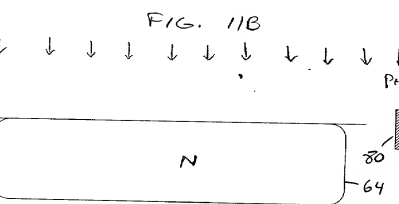


FIG. 12B

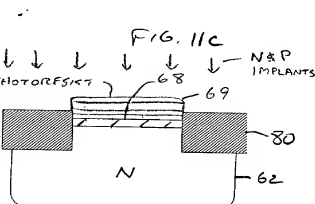


FIG. 12C

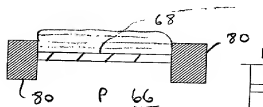


FIG. 13A

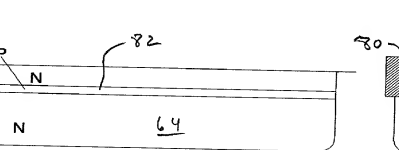


FIG. 13B

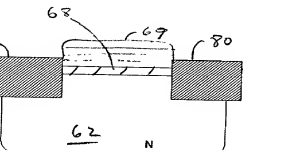


FIG. 13C

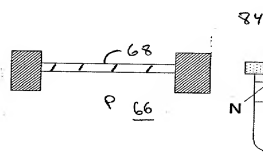


FIG. 14A

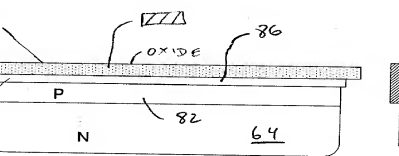


FIG. 14B

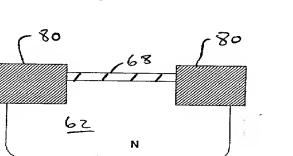


FIG. 14C

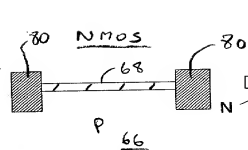


FIG. 15A

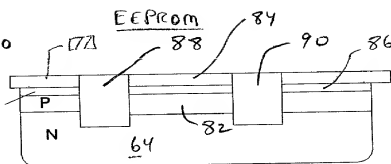


FIG. 15B

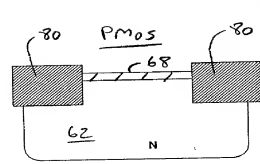


FIG. 15C

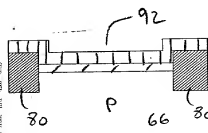


FIG. 16A

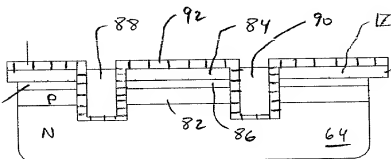


FIG. 16B

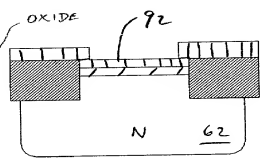


FIG. 16C

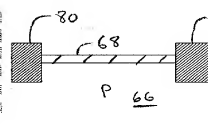


FIG. 17A

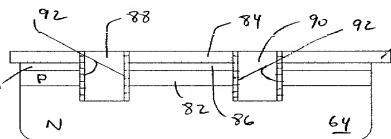


FIG. 17B

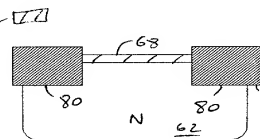


FIG. 17C

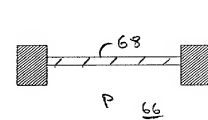


FIG. 18A

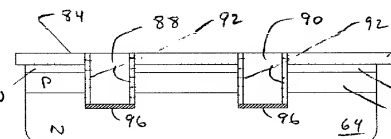


FIG. 18B

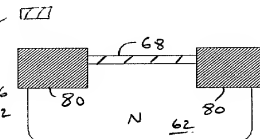


FIG. 18C

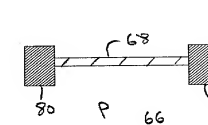


FIG. 19A

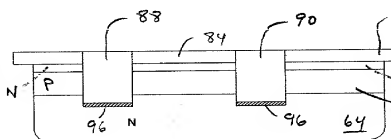


FIG. 19B

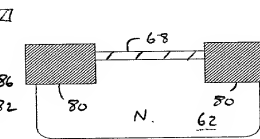


FIG. 19C

EEPROM

NMOS



FIG. 20A

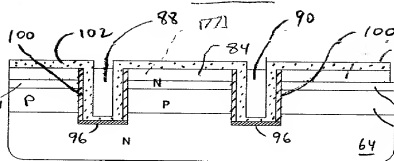


FIG. 20B

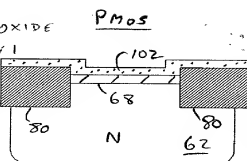


FIG. 20C

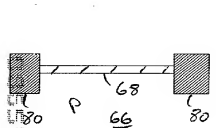


FIG. 21A

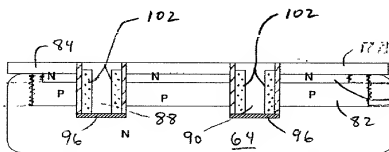


FIG. 21B

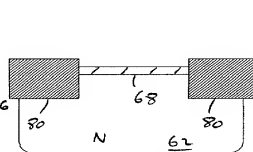


FIG. 21C

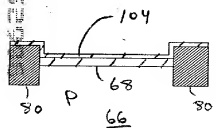


FIG. 22A

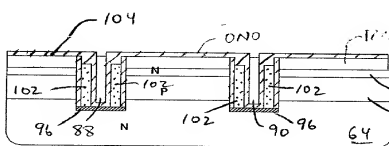


FIG. 22B

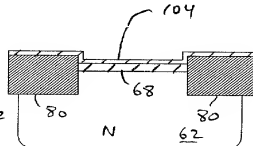


FIG. 22C

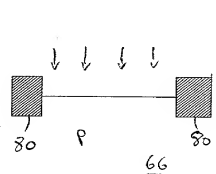


FIG. 23A

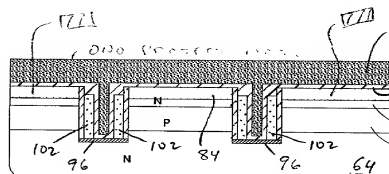


FIG. 23B

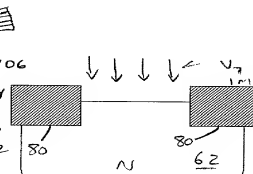


FIG. 23C

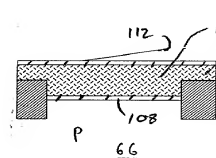


FIG. 24A

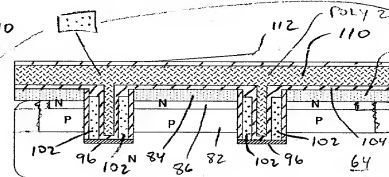


FIG. 24B

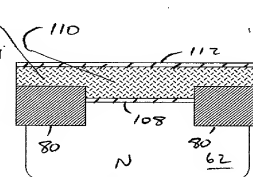


FIG. 24C

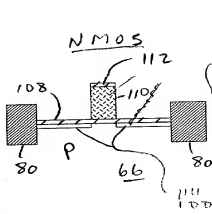


FIG. 25A

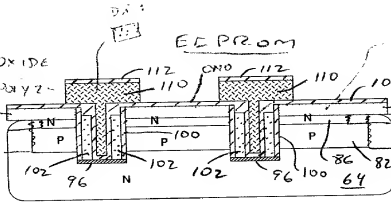


FIG. 25B

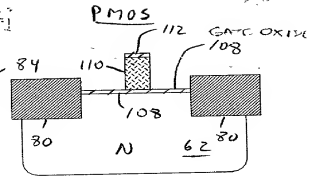


FIG. 25C

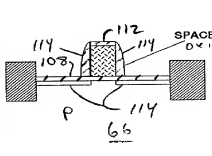


FIG. 26A

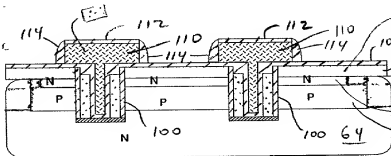


FIG. 26B

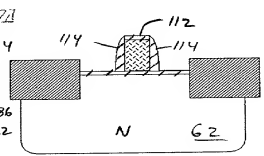


FIG. 26C

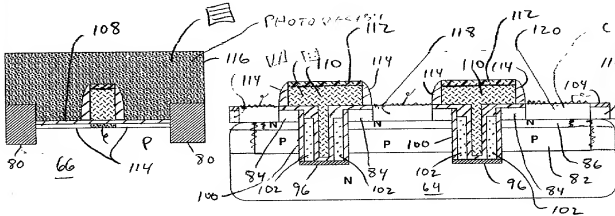


FIG. 27A

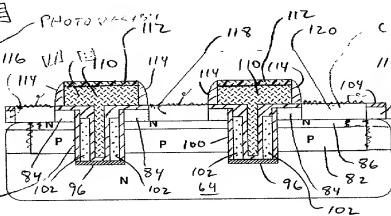


FIG. 27B

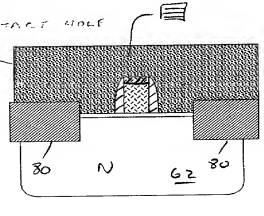


FIG. 27C

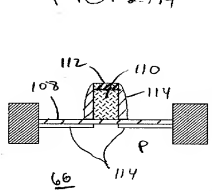


FIG. 28A

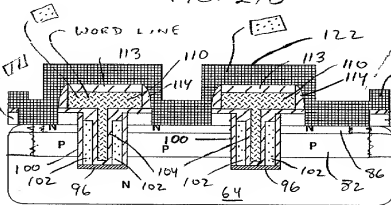


FIG. 28B

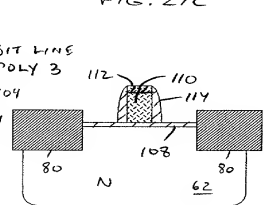


FIG. 28C

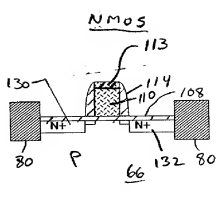


FIG. 29A

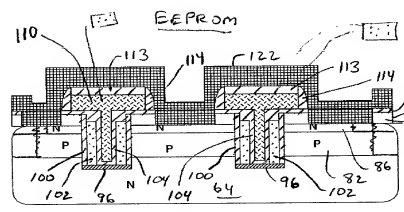


FIG. 29B

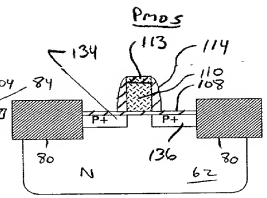


FIG. 29C

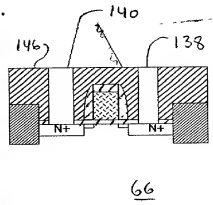


FIG. 30A

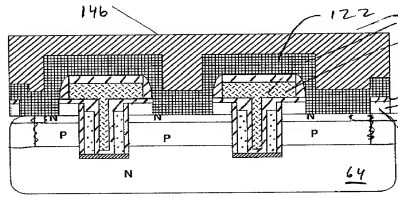


FIG. 30B

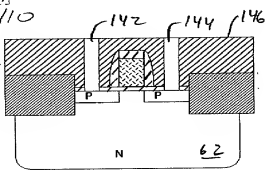


FIG. 30C

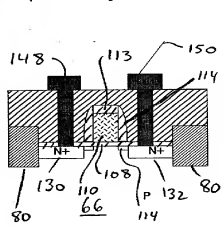


FIG. 31A

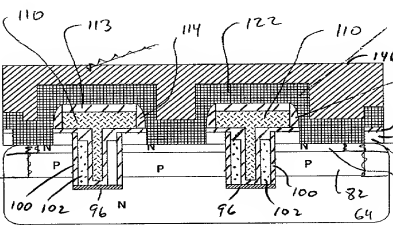


FIG. 31B

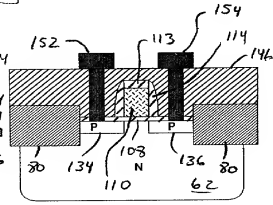
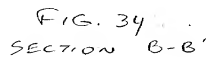
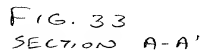


FIG. 31C

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May '96- 16:53 No.005 P.02



IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

File Application of) Art Unit: unknown
))
Madhukar B. Vora) Examiner: unknown
))
) Docket No: V&F-001
Serial No.: not yet assigned)
))
Filed: herewith)

For: VERTICALLY INTEGRATED FLASH EEPROM FOR GREATER DENSITY AND LOWER COST

Honorable Commissioner
of Patents and Trademarks
Washington, D.C. 20231

INDEPENDENT INVENTOR'S DECLARATION

Dear Sir:

The undersigned Applicant for the above application hereby states in accordance with 37 CFR Sections 1.9 and 1.27 that he is an independent inventor who has not assigned, granted, conveyed or licensed, and who is under no obligation under contract or law to assign, grant, convey, or license, any rights in the invention described in the above application to any person who could not likewise be classified as an independent inventor if that person had made the invention, or to any concern who would not qualify as a Small Business Concern or a non-profit organization under 37 CFR Section 1.9 (c).

I hereby acknowledge the duty to file, in this application or patent, notification of any change in status resulting in loss of entitlement to small entity status prior to paying, or at the time of paying, the earliest of the issue fee or any maintenance fee due after the date on which status as a small business entity is no longer appropriate. (37 CFR 1.28(b).)

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application, any patent issued thereon.

Respectfully Submitted,


Madhukar B. Vora

5-7-96

Date

I hereby certify that all of the above identified correspondence is being deposited with the United States Postal Service as Express Mail in an envelope addressed to: COMMISSIONER OF PATENTS AND TRADEMARKS, WASHINGTON, D.C. 20231 on 5-29-96

Express Mail Receipt Number
EF236633917US

Date: 5/29/96

Ronald C. Fish
Ronald Craig Fish, President
Reg. No. 28 843

DECLARATION FOR PATENT APPLICATION

Inventor(s): Madhukar B. Vora
Docket No. V&F-001

As a below-named inventor, I hereby declare that:

My correct residence, post office address and citizenship are stated below next to my name.

I believe myself to be the original, first and sole inventor (if only one name is listed below) or an original and first joint inventor (if more than one name is listed below) of the subject matter which is disclosed and claimed and for which a patent is sought on the invention entitled:

The specification of this subject matter:

☒ is attached hereto.

☐ was filed on _____;

was assigned serial No. _____;

which was amended on _____.

I hereby state that I have reviewed and understand the contents of the above identified patent application, including the claims, as amended by any amendment(s) referred to above. I believe the subject matter claimed in the above-identified application to be new and to be unobvious to persons of ordinary skill in the art in view of the prior art of which I am aware. I further hereby state that the specification of the above identified patent application adequately describes how to make and use the claimed invention, and further that it sets forth the best mode for practicing the invention known to me as of the date that the application was filed. I acknowledge the duty to disclose information which is material to the examination of this application in accordance with 37 C.F.R. 1.56. I further acknowledge the duty to disclose information known to me to be material under 37 C.F.R. 1.56 to the examination of the claims in any continuation-in-part application filed under the conditions specified in 35 U.S.C. Section 120 which became available between the filing date of the prior application or the national or PCT international filing date and the filing date of the continuation-in-part application.

I hereby claim foreign priority benefits under 35 U.S.C. §119 of any foreign application(s) for patent or inventor's certificate listed below and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed.

Application No.	Country	Filing Date	Priority Claimed
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I hereby claim the benefit under 35 U.S.C. §120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in these prior United States application(s) in the manner provided by 35 U.S.C. §112, I acknowledge the duty to disclose material information as defined in 37 C.F.R. §1.56(a) which

Docket Number V&F-001

PATENT

occurred between the filing date of the prior application(s) and the national or PCT international filing date of this application.

Application No.	Filing Date	Status (Issued, Pending, Abandoned)
10/2017	10/2017	Issued
11/2017	11/2017	Pending
12/2017	12/2017	Abandoned

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FULL NAME OF INVENTOR 2	FIRST Name	MIDDLE Initial(s)	LAST Name	
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I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and to transact all business in the United States Patent and Trademark Office connected therewith:

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I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Title 18, United States Code, § 1001 and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

Signature of Inventor 1 5-7-96 Date Signature of Inventor 2 Date